

Date: Thursday, 5/31/2007 7:23:47 AM  
User: Kim Johnston

## Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT  
Job Number : 32721 EFFECTIVE 07-06-27 AUTH 6  
Estimate Number : 12577 RELEASED \_\_\_\_\_ DATE \_\_\_\_\_  
P.O. Number : N/A Part Number : D3562042  
This Issue : 5/31/2007 S.O. No. : N/A Drawing Number : D3562 UNDER REVIEW  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A  
Previous Run : 32720 Material : N/A  
Written By : Due Date : 6/30/2007 Qty: 6 Um: Each  
Checked & Approved By : 07.05.31  
Comment : Est Rev. A New Issue 06-11-09 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 331984

Check Material for any Dents or Defects

Q.M. 07-06-27

6

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap 330883PE. 07-06-27

6

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

Q.M. 07-06-27

6

2-Deburr and bevel ends for welding

Q.M. 07-06-27

6

3-Weld (1)end cap as per Dwg D3562&amp; QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M102756M104305

4-Grind end cap welds flush as per Dwg D3562

PE. 07-06-27

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/04	#20 + 33	Put step <del>#2</del> <sup>#2 and #33</sup> after step or part of step #14 PERMANENT CHANGE	ES	07/07/04	-		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 32721

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562. USING DT 8956

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

10.0

D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

Batch: 332648

11.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Blind Rivet

batch: M 8953

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

A/R Magnabond 6398

Batch:

M104679

FF 07-07-03

6

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/04 (46)

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M102756

2-Grind end cap welds flush as per Dwg D3562

Q.A

07.07.10

6

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

En 07/07/10 (6)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/11 (6 LRS)

All 6 were tested on the Helicopter

17.0

POWDER COATING

TOUCH-UP ALLOCUT POWDER COATING

En 07-07-16



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/M/07-07-17

(6)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M104733

FF

07/07/17

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

07.07.17

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit



Job Completion



U. O. A. 18  
POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

QC 21 07.07.18

19.1 - Pick 2 02808 Bushings B 32752 x 12mm  
- Press fit as per Dwg.

19.2 QC 5 - 07.07.18 x 6

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



**DART**

RELEASED

01.01.2008

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

1.00

45.0°

D2734 END PLATE

**TYPICAL STEP END DETAIL**  
NOT TO SCALE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32721

D3562-1,  
MAKE FROM  
EXTRUSION D2622

APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

D3560-043 ARM WELDMENT (FOR D3562-041, SHOWN)  
OR D3560-044 ARM WELDMENT (FOR D3562-042, OPPOSITE)

D3560-041 ARM WELDMENT (FOR D3562-041, SHOWN)  
OR D3560-042 ARM WELDMENT (FOR D3562-042, OPPOSITE)

FWD.

4.30 71.707 9.20 (REF)  
85.15  
MEASURED BEFORE END CAPS WELDED IN PLACE

REFER TO STEP  
END DETAIL

TRANSFER DRILL #30  
INSTALL MS20600AD4W5  
RIVET (36 PLACES),  
DEBURR & TOUCH UP HOLES  
WITH CHEMICAL CONVERSION  
COAT BEFORE RIVETING,  
TOUCH-UP RIVET HEADS  
WITH PAINT PER  
DART QSI 005 4.2

**D3562-041 LH STEP ASSEMBLY (SHOWN)**  
**D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004
- 3) FINISH:

AFTER WELDING END PLATES AND PRIOR TO DRILLING/INSTALLING ARM WELDMENTS:

- i) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - ii) POWDER COAT GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) INSTALL ARM WELDMENTS WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN THE ARM WELDMENT AND STEP EXTRUSION
  - 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CP	CP	
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3562
DATE	TITLE	REV. B
07.01.15	STEP ASSEMBLY	SHEET 1 OF 1
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
		SCALE N/A